

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016197**Date Inspected:** 06-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – Document No: 006344

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 11EW. The weld designations reviewed are as follows:

1. SEG 073\*-001, 002, 003,
2. SEG073C-001, 002, 003, 009, 010, 011, 012

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 045270 perform Submerged Arc Welding (SAW) Welding on OBG Segment 13BW, weld joint identified as SEG3015A-013. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 058100 perform SAW Welding on OBG Segment 13BE, weld joint identified as SEG3009A-007. ZPMC QC is identified as Mr. Wang Xu. The

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA inspector observed ZPMC qualified welding personnel identified as 044780 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as SEG3009A-007. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062806 perform FCAW welding on Suspender Bracket, weld joint identified as SB019-076-004. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062794 perform FCAW welding on Suspender Bracket, weld joint identified as SB020-080-105. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F.

Description of Incident: During the Quality Assurance (QA) random in-process visual inspection this QA inspector observed Segment 13 Floor Beam components that appear to have been bent due to improper handling and /or storage. These Floor Beam components are identified as FB3132-001 and FB3156-001. The red tag numbers are identified as 13990 and 13991. These Floor Beam are located in the East side of Bay 14. For further information, please see the attached pictures below.

Visual Inspection after Blast

Segment 10CE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 10CE PP092 to 94.4, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

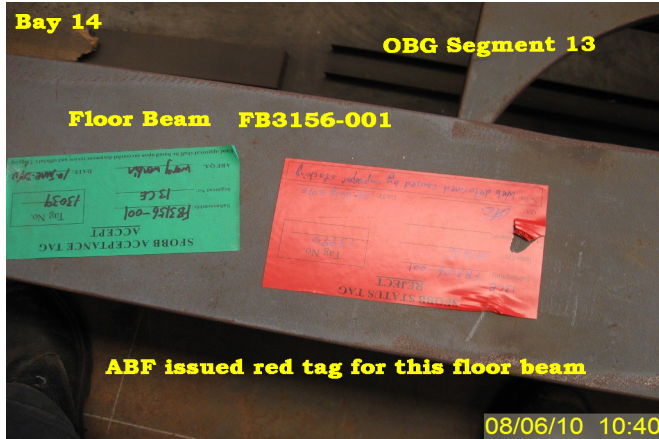
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer